

AMENDMENTS TO THE CLAIMS

In accordance with the required format for making amendments as set forth in 37 C.F.R. § 1.121, amendments to the present claims are made with additions being indicated by way of underlining and deletions being indicated by way of strikethroughs. Additionally, each claim is provided with a status identifier in parenthetical immediately following its respective claim number.

1. (Presently Amended) A method for manufacturing a multi-layer film for use in vacuum packaging applications, ~~said multi-layer film having a pattern that operates to form channels suitable for evacuation of gas when said multi-layer film is used in the creation of a vacuum packaging bag;~~ said method comprising the acts of:

heat-extruding a first material onto a spinning cooling roll;

heat-extruding a second material onto said spinning cooling roll such that said first and second extruded materials bond in intimate and comprehensive contact and forming first and second layers of said multi-layer film during a cooling of said first and second extruded materials; and

applying a pattern to said first and second layers in conjunction with ~~said extrusion and said cooling of said first and second extruded materials such that said pattern is defined during said cooling of said first and second materials,~~ said pattern operable to form channels suitable for evacuation of gas from said vacuum packaging bag made of said multi-layer film.

2. (Original) A method for manufacturing a multi-layer film as recited in claim 1, wherein said first material is a heat-sealable resin.
3. (Original) A method for manufacturing a multi-layer film as recited in claim 2, wherein said second material is a gas impermeable material.
4. (Original) A method for manufacturing a multi-layer film as recited in claim 3, further including an act of heat-extruding a first bonding material in between said first and second material, said first bonding material forming a first bonding layer between said first and second layers.
5. (Original) A method for manufacturing a multi-layer film as recited in claim 4, further comprising the act of heat-extruding a second bonding material and a structural material to form a second bonding layer and a structural layer, said second bonding layer bonding said structural layer to said second layer, said structural layer intended to provide additional strength to said multi-layer film.
6. (Original) A method for manufacturing a multi-layer film as recited in claim 5, wherein said act of applying a pattern operates to apply said pattern to all five layers of said multi-layer film.

7. (Original) A method for manufacturing a multi-layer film as recited in claim 1, wherein the act of applying a pattern to said first and second layers is accomplished by providing said pattern on the circumferential surface of said cooling roll.
8. (Original) A method for manufacturing a multi-layer film as recited in claim 7, further including the act of positioning a laminating roll to apply pressure to the extruded materials in order to apply said pattern formed on the circumferential surface of said cooling roll onto said multi-layer film.
9. (Original) A method for manufacturing a multi-layer film as recited in claim 8 further including the act of controlling a temperature of said cooling roll in order to properly effectuate cooling and formation of said first and second layers.
10. (Original) A method for manufacturing a multi-layer film as recited in claim 1, wherein the act of applying a pattern to said extruded layers is accomplished by extruding said materials over a patterned cooling plank which in turn directs said extruded materials to flow over said cooling roll.
11. (Presently Amended) A method for manufacturing a multi-layer film as recited in claim 2 10, further including the act of controlling a temperature of said cooling plank to properly effectuate cooling and formation of said first and second layers.

12. (Original) A method for manufacturing a multi-layer film as recited in claim 1, wherein said pattern is a zigzag pattern.

13. (Original) A method for manufacturing a multi-layer film as recited in claim 1, wherein said channels formed by said pattern have a varying width thereby retarding fluid flow therethrough.

14. (Presently Amended) A method for manufacturing a vacuum packaging bag, said method comprising:

a) forming a first patterned film sheet including:

i) heat-extruding a first material onto a spinning cooling roll;

ii) heat-extruding a second material onto said spinning cooling roll such that said first and second materials bond in intimate and comprehensive contact and forming first and second layers of said first patterned film sheet during a cooling of said first and second extruded materials; and

iii) applying a pattern to said first and second layers in conjunction with said ~~extrusion and said~~ cooling of said first and second extruded materials ~~such that said pattern is defined during said cooling of said first and second materials~~, said pattern operable to form channels suitable for evacuation of gas from said vacuum packaging bag made of said first and second patterned film sheet;

b) bonding a second film sheet onto said first film sheet via sealing opposing sides to form a pouch with two open ends;

- c) sizing said pouch to a desired size; and
- d) bonding a one of said open ends to form a vacuum packaging bag.

15. (Original) A method of manufacturing a vacuum packaging bag as recited in claim 14, wherein said pattern is a zigzag pattern.

16. (Original) A method of manufacturing a vacuum packaging bag as recited in claim 14, wherein said second film sheet is patterned.

17. (Presently Amended) A method of manufacturing a vacuum packaging bag as recited in claim 14, wherein ~~said bonding said second film sheet onto said first film sheet~~ includes applying heat along said opposing sides.

18. (Presently Amended) A method of manufacturing a vacuum packaging bag as recited in claim 14, wherein ~~said bonding said second film sheet onto said first film sheet~~ includes applying pressure along said opposing sides.

19. (Original) A method for manufacturing a roll of vacuum packaging bag material, said material comprising:

- a) forming a first patterned film sheet including:
 - i) heat-extruding a first material onto a spinning cooling roll;

ii) heat-extruding a second material onto said spinning cooling roll such that said first and second materials bond in intimate and comprehensive contact and forming first and second layers of said first patterned film during a cooling of said first and second extruded materials; and

iii) applying a pattern to said first and second layers in conjunction with said ~~extrusion and said cooling of said first and second extruded materials such that said pattern is defined during said cooling of said first and second materials~~, said pattern operable to form channels suitable for evacuation of gas from said vacuum packaging bag made of said first and a second patterned film sheet;

b) bonding said a second film sheet onto said first film sheet via sealing opposing sides to form a pouch with two open ends; and

c) forming said pouch into said roll of vacuum packaging material.

20. (Original) A method for manufacturing a roll as recited in claim 19, wherein said pattern is a zigzag pattern.

21. – 56. (Canceled)

57. (Presently Amended) Said method as recited in claim 56 Z wherein said ~~rotating~~ cooling roller contains an inverse-pattern that imparts a pattern onto said vacuum packaging film.

58. (Canceled)

59. (Presently Amended) Said method as recited in claim 58 ~~10~~ wherein said cooling plank contains an inverse-pattern that imparts a pattern onto said vacuum packaging film.

60. (Presently Amended) A method for making vacuum packaging film comprising:

~~flowing a plastic melt, from a multi-layer extruder; heat-extruding a first material in said the vicinity of an air-knife; and~~

~~cooling said plastic melt, as it flows heat-extruding a second material such that said first and second extruded materials bond in intimate and comprehensive contact forming first and second layers of said multi-layer film during a cooling of said first and second extruded materials in said the vicinity of said air-knife, into a vacuum packaging film; and~~

~~applying a pattern to said first and second layers in conjunction with said cooling of said first and second extruded materials, said pattern operable to form channels suitable for evacuation of gas from a vacuum packaging bag made of said multi-layer film.~~

61. (Original) A method as recited in claim 60 wherein said air-knife in an inverse-vacuum.

62. (Presently Amended) A method as recited in claim 60 wherein said air-knife imparts a ~~said~~ pattern onto said vacuum packaging film.

63. (Original) A method as recited as in claim 61 wherein said air-knife imparts a said pattern onto said vacuum packaging film.

64. - 65. (Canceled)

In making the above amendments, no new matter is believed added.